

ASAP
Work Order ID 51716

August 28, 2009 9:09:02 AM

Page 1

Item ID: D3781-1

Accept

Setup Start

Revision ID: D

Stop

Item Name: Supporting Plate

Start Date: 8/31/09 Start Qty: 6.00

Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3781

Rev D

10

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3781-1

Dwg Rev: *D*

Prog Rev: *D*

2- Deburr if necessary

FB 9-8-31

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FB 9-8-31

(10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 51716



Page 2

August 28, 2009 9:09:02 AM

Item ID: D3781-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Supporting Plate

Start Date: 8/31/09 Start Qty: 6.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

=> 809/08/31

(XO) /

QC

Memo

0.00

Quality Control

130

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-counter sink holes as per dwg D3781
2- deburr if necessary

809/08/31 (XO)

140

QC5- Inspect part completeness to step on W/O

0.00

=> 809/08/31

(XO) /

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 51716

August 28, 2009 9:09:02 AM



Page 3

Item ID: D3781-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Supporting Plate

Start Date: 8/31/09 Start Qty: 6.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

GR 09-08-31 (10)

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 09/08/31 (10)

170

0.00



Small Fab

Memo

0.00

Small Fab

1- assemble nut plate as per dwg

EP 09/08/31 (10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 51716

August 28, 2009 9:09:02 AM



Page 4

Item ID: D3781-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Supporting Plate

Start Date: 8/31/09 Start Qty: 6.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

SHIP TO AEROTEK
w FOR W/O 51714

9/8/31 10x SP

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/01

MF 09-08-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

August 28, 2009 9:09:02 AM

Page 1 *1/2*

Work Order ID: 51716

Parent Item: D3781-1RevD

Parent Item Name: Supporting Plate


Comments:

Start Date: 8/31/09

Required Date: 9/04/09

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6S.080 | | Purchased | No | | | 100 | sf | 270.4990 | 0.6707 | | | |
|  | | | | | | | | | | | | |
| 6061-T6 .080 Sheet | | | | | | | | | | | | |

189-2-31

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 270.499 | |
| 107904 | 0.02 | |
| 110254 | 2.5 | |
| 110630 | 42.9353 | |
| 112040 | 0.0437 | |
| 112141 | 33 | |
| 112512 | 192 | |

112512

MS20426AD3-3

Purchased

No

170

Each

7,486.000

24.0000



Rivet

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 7486 | |
| 1563 | 0 | |
| 19099 | 4776 | |
| 7681 | 2710 | |

40

8/31/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 2

August 28, 2009 9:09:02 AM

Work Order ID: 51716



Parent Item: D3781-1RevD



Parent Item Name: Supporting Plate

Start Date: 8/31/09

Required Date: 9/04/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS21075L3 | | Purchased | No | | | 170 | Each | 123.0000 | 12.0000 | | | |



Nutplate



~~13-28-31~~

Ep09/08/31

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 123 | |
| 109068 | 12 | |
| 109371 | 39 | |
| 110704 | 37 | |
| 111477 | 15 | |
| 112314 | 20 | |

(37) 7x

August 28, 2009 9:09:02 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

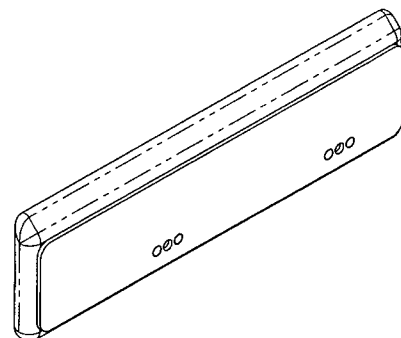
| | | |
|---------------------------|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 51716 |
| Description: | Part Number: | D3781-1 |
| Supporting PLATE | | |
| Inspection Dwg: | Rev: | Page 1 of 1 |
| D3781-1 | D | |

FIRST ARTICLE INSPECTION CHECKLIST

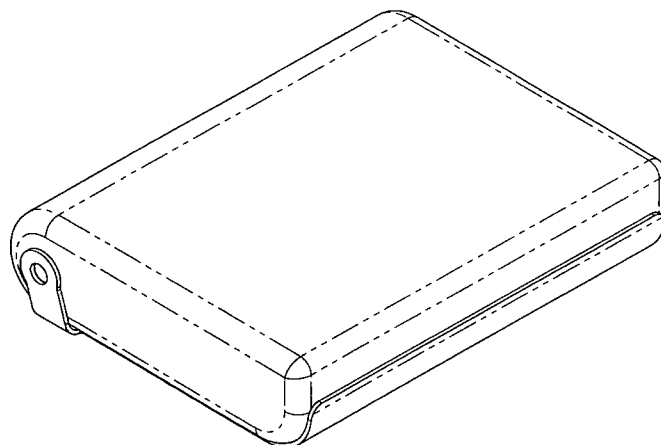
☒ **First Article** ☐ **Prototype**[illegible]

| | | |
|------------------------|-----------------------|------------------------------|
| Measured by: IB | Audited by: S | Prototype Approval: 1 |
| Date: 9-8-31 | Date: 09/08/31 | Date: 1/4 |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |



D3781-041 LATERAL CUSHION ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



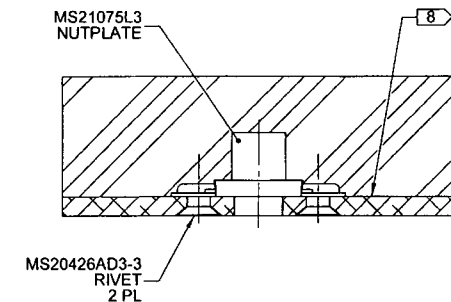
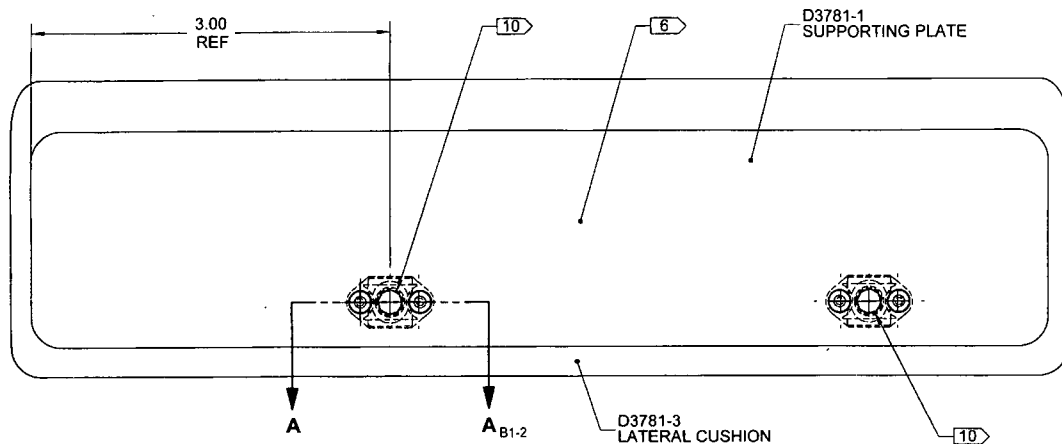
D3781-043 ARMREST CUSHION
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

W/O 51716

RELEASED
09/07/21

| | | | |
|--|--|--------------|----------|
| D | REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009 | MB | 09.05.21 |
| C | REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS | MB | 08.11.10 |
| B | REDESIGNED; ADDED DETAIL A (ZN B7-1) | MB | 08.07.15 |
| A | NEW ISSUE | MB | 08.04.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | ASS | | |
| MFG. APPR. | | | |
| APPROVED | AM | | |
| DE APPR. | | | |
| DATE | 09.05.21 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWING NO. D3781 | | REV. D | |
| TITLE CUSHION ASSEMBLY | | SHEET 1 OF 6 | |
| | | SCALE NTS | |
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| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|--------------|--|
| 1 | X | D3781-041 | CUSHION ASSEMBLY |
| 11 | 1 | D3781-1 | SUPPORTING PLATE |
| 12 | 1 | D3781-3 | LATERAL CUSHION |
| 22 | 2 | MS21075L3 | NUT PLATE (OR MS21075-3) |
| 23 | A/R | SY-111 | SURREY SILVER SUNSET UPHOLSTERY FABRIC |
| 24 | A/R | 1300 | 3M SCOTCH-GRIP ADHESIVE |
| 25 | 4 | MS20426AD3-3 | RIVET |



D3781-041 LATERAL LATERAL CUSHION ASSEMBLY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

D3781-041 NOTES:

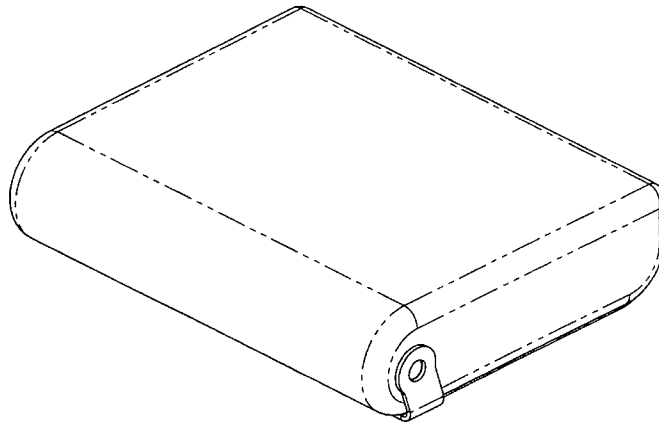
- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC

| | | | |
|------------|----------|--|--------------|
| DESIGN | 1 | DART AEROSPACE LTD | |
| DRAWN | 1 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. D3781 | REV. D |
| MFG. APPR. | ND | | SHEET 2 OF 6 |
| APPROVED | AM | TITLE | SCALE |
| DE APPR. | 4 | CUSHION ASSEMBLY | NTS |
| DATE | 09.05.21 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

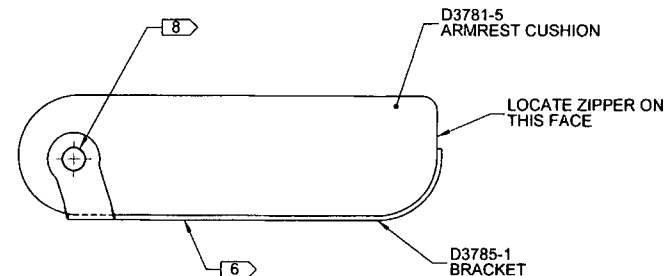
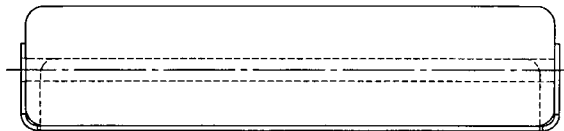
RELEASED
9/16/14

51714

| ITEM | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-----------|---|
| 1 | X | D3781-043 | ARMREST CUSHION ASSEMBLY |
| 11 | 1 | D3785-1 | BRACKET |
| 12 | 1 | D3781-5 | ARMREST CUSHION |
| 21 | A/R | SY-111 | SURREY SILVER SUNSET UPHOLSTERY FABRIC |
| 22 | A/R | 1300 | 3M SCOTCH-GRIP ADHESIVE |



D3781-043 LATERAL ARMREST CUSHION BASE ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-043 NOTES:

- 1) MATERIAL: COVER D3781-5/D3785-1 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
ZIPPER P/N: AI-2021
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) DO NOT COVER HOLES WITH FABRIC

RELEASED
09/07/21

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3781 | REV. D |
| MFG. APPR. | | | SHEET 3 OF 6 |
| APPROVED | | TITLE CUSHION ASSEMBLY | SCALE NTS |
| DE APPR. | | | |
| DATE | 09.05.21 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COME OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

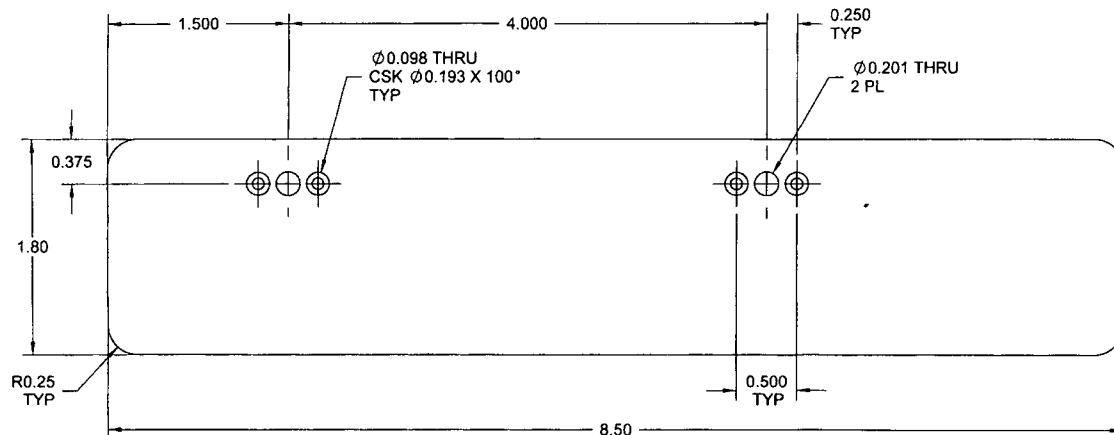
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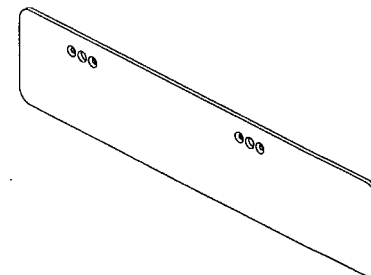
C

B

A



D3781-1 SUPPORTING PLATE

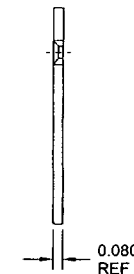


D

C

B

A



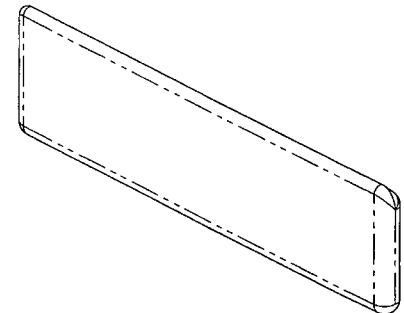
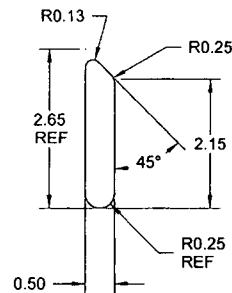
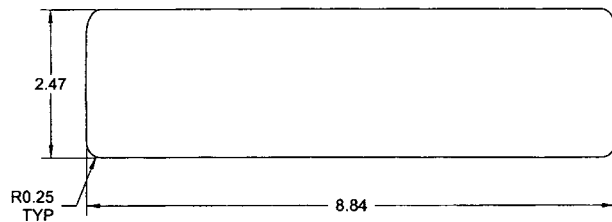
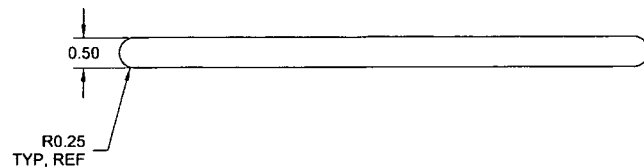
51716
RELEASED
09/04/10

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3781 | SHEET 4 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CUSHION ASSEMBLY | NTS |
| DATE | 09.05.21 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

8 7 6 5 4 3 2 1



D3781-3 LATERAL CUSHION

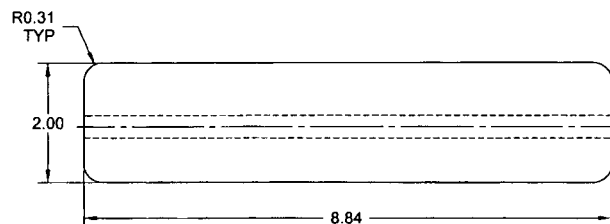
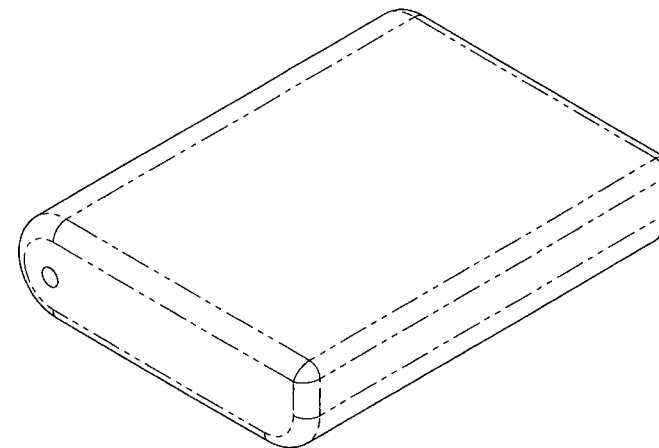
D3781-3 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

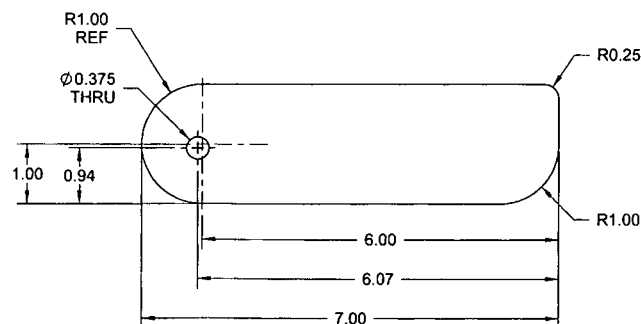
| | | | |
|------------|-----------------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3781 | SHEET 5 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CUSHION ASSEMBLY | NTS |
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51716
RELEASED
9/16/21 MP

8 7 6 5 4 3 2 1



D3781-5 ARMREST CUSHION



51716
RELEASED

D3781-5 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. | REV. D |
| MFG. APPR. | | D3781 | SHEET 6 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CUSHION ASSEMBLY | NTS |
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